Dart Aerospace Ltd. Friday, 11/24/2006 11:15:56 AM Kim Johnston User **Process Sheet** : JET **Drawing Name** Customer : CU-DAR001 Dart Helicopters Services Job Number : 29689A : 10583 **Estimate Number** : D2003077 Part Number P.O. Number . UNDER REVIEW C 6 06.11.24 : 11/24/2006 **Drawing Number** S.O. No. : This Issue : N/A Prsht Rev. : NC Project Number : SMALL /MED FAB : 11 Type **Drawing Revision** ; A First Issue : 27698 Material **Previous Run** : 12/1/2006 Each Qty: 2 Um: **Due Date** Written By Checked & Approved By New issue KJ/JLM Comment **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: M6061T6T0375W035 6061-T6 Tube .375 x.035W 1.0 Comment: Qty. 1.0625 f(s)/Unit Total: 2.1250 f(s) 6061-T& Tube .375 x.035W Material: 6061-T6 tubing 0.375OD x 0.035" wall (M6061T6T0.375W.035) SMALL & MEDIUM FAB RESOURCE 1 2.0 SMALL FAB Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Cut (2) D2003-077 blanks per (1) DSI 9051 Kit 2- Cut blanks: 6.250" long as per template D2003-077 3- Form, drill & flare as per template D2003-077 Identify for D2003-077 Set Screw 3.0 516IN200 2.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Set Screw Pick: Qty Part Number Description Batch 2 5/16"-.200 Set Screw AN8186D Nut 4.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut Pick:

Qty 2 Part Number

AN818-6D

Description

Nut

Batch

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No	<u>.</u>	PAR #: Fault Category: NCF	R: Yes	s No DQA	١:	Date:							

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	losed:	Date:

	`	WORK ORD	ER NON-CONFORMANO	E (NCR)			
	Description of NC		Corrective Action Section B	Verification	Approval	Approval	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							:
	·						
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng

NOTE: Date & initial all entries

Date: űser:

Friday, 11/24/2006 11:15:56 AM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JET

Job Number: 29689A

Part Number: D2003077

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MS208196D

Sleeve

Comment: Qty.:

2.0000 Each(s)/Unit

Total:

4.0000 Each(s)

Sleeve Pick:

Qty

Part Number

Description

Batch

2

MS20819-6D

Sleeve

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

QC5



Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2003



Identify as D2003-077



INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

8.0

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

9.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 26.11.24

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W/O:		WORK ORDER CH	WORK ORDER CHANGES												
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector								
			:												
	:														
Part No) :	PAR #: Fault Category:	NCR: Yes	No DQ	 A :	Date:	<u> </u>								

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)	(NCR)								
<u> </u>		Description of NC		Corrective Action Section B		Verification	A	A						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector						
:						:								
				·										

NOTE: Date & initial all entries





	Q .								
DESIG	4	DRAWN BY	DART AEROSPACE LTD hawkesbury, ontario, canada						
CHEC	KED	APPROVED	DRAWING NO. REV. B						
4	10	1 47	D2003 SHEET 1 OF 2						
DATE	,		TITLE SCALE						
 99.0	06.08		206 CABIN HEATER TUBE ASSEMBLIES NTS						
Α		90.04.09	NEW ISSUE						
В		99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)						

NAKE PARTS PER THE BENT TEMPLATE UNDER REVIEW Some Flot

USE FLAT LENGTHS AS REFERENCE.

CC. OS. 21 CP JEMBY WIGHT

SHOP COPY

PIN TEMPLATE PIN	PORT COL	RET FLAT				133	.0%.			<u>ا ا ا</u>	myths wrong	RETURN TO ENGINEERING	T
D2003-001 T2003-005 52 6.00	P/N	TEMPLATE	HEATSLEEVE LENGTH1	CUT LENGTH (REF)	MS20819-8J SLEEVE	AN818-8J NUT	MS20819-8D SLEEVE	AN818-8D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESC.	UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 29687 A	VENDOR OR
Decision			5.2	6.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005 T2003-005 9.8 10.62 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-007 T2003-009 12.38 12.44 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-009 T2003-009 12.38 12.44 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-011 T2003-011 33.31 32.38 2 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-013 T2003-013 12.7 13.54 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-015 T2003-015 17.2 18.00 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-017 T2003-015 17.0 16.25 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-017 T2003-017 17.0 16.25 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-021 T2003-021 N/A 2.25 2 2 TUBE ASSY 6061-T6 0.375 OD x 0.035 W WW-T-70 D2003-023 T2003-023 45 53.33 2 2 2 TUBE ASSY 6061-T6 0.000 OD x 0.035 W WW-T-70 D2003-027 T2003-027 45 53.33 2 2 2 TUBE ASSY 6061-T6 0.500 OD x 0.035 W WW-T-70 D2003-027 T2003-023 7.25 7.38 2 2 2 TUBE ASSY 6061-T6 0.500 OD x 0.035 W WW-T-70 D2003-027 T2003-027 7.25 7.38 2 2 2 TUBE ASSY 6061-T6 0.500 OD x 0.035 W WW-T-70 D2003-029 T2003-029 17.2 18.00 2 2 TUBE ASSY 6061-T6 0.500 OD x 0.035 W WW-T-70 D2003-021 T2003-033 14.6 15.38 2 2 TUBE ASSY 6061-T6 0.500 OD x 0.035 W WW-T-70 D2003-027 T2003-039 34.0 34.0 2 2 TUBE ASSY CRES 0.500 OD x 0.035 W WW-T-70 D2003-031 T2003-033 29.75 29.62 2 2 TUBE ASSY CRES 0.500 OD x 0.035 W WW-T-70 D2003-031 T2003-033 34.7 34.0 2 2 TUBE ASSY CRES 0.500 OD x 0.035 W WW-T-70 D2003-031 T2003-033 34.7 34.0 2 2 TUBE ASSY CRES 0.500 OD x 0.035 W ASS D2003-043 T2003-044 31.1 10.75 2 2 TUBE ASSY CRES 0.500 OD x 0.035 W ASS D2003-041 T2003-047 5.56 5.56 2 2 TUBE ASSY CRES 0.500 OD x 0.035 W WW-T-70 D				8.12					2	2			WW-T-700/6
D2003-007 T2003-007 20.0 19.63										2			WW-T-700/6
D2003-009					-								WW-T-700/6
Decision									2	2		<u> </u>	WW-T-700/6
Decomposition Tecono Tec											TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015 T2003-015 T7.0 18.00			12.7						2			6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019 T2003-019 T2003-019 T2003-019 T2003-021 T2003-021 T2003-021 T2003-021 T2003-021 T2003-023 T2003-023 4.5 5.33 2 2 TUBE ASSY G061-T6 0.500 OD x 0.035 W WW-T-70 T2003-025 T2003-027 T2003-027 T2003-027 T2003-027 T2003-027 T2003-027 T2003-027 T2003-027 T2003-027 T2003-029 T1.2 T2.8 T2.8		T2003-015	17.2	18.00					2		TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-021 T2003-021 N/A 2.25 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-700 D2003-023 T2003-023 4.5 5.33 2 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-700 D2003-025 P3 P3 P3 P3 P3 P3 P3 P			17.0	16.25							TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-023 T2003-023 4.5 5.33 2 2 2 TUBE ASSY 6061-T6 0.500 OD x 0.035 W WW.T-700			9.8	10.62			2	2				6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025 T2003-025 9.8 10.60 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-700	D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027 T2003-027 T203-027 T.25 T.38	D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/
D2003-029	D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/
D2003-031 T2003-031 14.6 15.38 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3	D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/
D2003-033 T2003-033 29.75 29.62 2 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-035 T2003-035 Z4.7 Z7.00 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-037 T2003-037 Z4.81 Z3.38 Z 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-039 T2003-039 34.0 34.00 Z 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-041 T2003-041 6.0 5.88 Z 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-043 T2003-043 T1.7 T1.75 Z Z TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-045 T2003-045 T2003-045 T2003-045 T2003-045 T2003-045 T2003-047 T2003-047 T2003-047 T2003-047 T2003-049 T2003-	D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASS'Y		WW-T-700/
D2003-035 T2003-035 Z4.7 Z7.00 Z Z TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3	02003-031	T2003-031	14.6	15.38		2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037 T2003-037 Z4.81 Z3.38 Z Z TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3	D2003-033	T2003-033	29.75	29.62	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039 T2003-039 34.0 34.00 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3	D2003-035	T2003-035	24.7	27.00							TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041 T2003-041 6.0 5.88 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3	D2003-037	T2003-037	24.81	23.38	2	2						CRES 0.500 OD x 0.035 W	AISI 304
D2003-043 T2003-043 11.7 10.75 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3	D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045 T2003-045 3.50 2.44 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-047 T2003-047 5.56 5.56 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-049 T2003-049 33.2 34.00 2 2 TUBE ASS'Y CRES 0.500 OD x 0.035 W AISI 3 D2003-077 T2003-077 N/A 6.25 1 1 JET 6061-T6 0.375 OD x 0.035 W WW-T-700 D2003-101 T2003-101 13.25 13.13 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-103 T2003-103 12.38 12.00 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-105 T2003-105 10.75 10.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-109 T2003-107 12.75 12.25 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-109 T20	D2003-041	T2003-041	6.0	5.88	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
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D2003-049 T2003-049 33.2 34.00 2 2 TUBE ASS'Y CRES 0.500 QD x 0.035 W AISI 3 D2003-077 T2003-077 N/A 6.25 1 1 JET 6061-T6 0.375 QD x 0.035 W WW-T-700 D2003-101 T2003-101 13.25 13.13 2 2 TUBE ASS'Y 6061-T6 0.375 QD x 0.035 W WW-T-600 D2003-103 T2003-103 12.38 12.00 2 2 TUBE ASS'Y 6061-T6 0.375 QD x 0.035 W WW-T-600 D2003-105 T2003-105 10.75 10.60 2 2 TUBE ASS'Y 6061-T6 0.375 QD x 0.035 W WW-T-600 D2003-107 T2003-107 12.75 12.25 2 2 TUBE ASS'Y 6061-T6 0.375 QD x 0.035 W WW-T-600 D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 QD x 0.035 W WW-T-600 D2003-110 T2003-111 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 QD x 0.035 W WW-T-600 D	D2003-045	T2003-045	3.50	2.44	2	2						CRES 0.500 OD x 0.035 W	AISI 304
D2003-077 T2003-077 N/A 6.25 1 1 JET 6061-T6 0.375 OD x 0.035 W WW-T-700 D2003-101 T2003-101 13.25 13.13 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-103 T2003-103 12.38 12.00 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-105 T2003-105 10.75 10.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-107 T2003-107 12.75 12.25 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-111 T2003-110 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-14 T2003-16 4.0	D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-101 T2003-101 13.25 13.13 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W VWV-T-600 D2003-103 T2003-103 12.38 12.00 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W VWV-T-600 D2003-105 T2003-105 10.75 10.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W VWV-T-600 D2003-107 T2003-107 12.75 12.25 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W VWV-T-600 D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W VWV-T-600 D2003-111 T2003-114 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W VWV-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-14 T2003-14 4.0 HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLE D2003-16 T2003-205 9.75 9.60 2 <td< td=""><td>D2003-049</td><td>T2003-049</td><td>33.2</td><td>34.00</td><td>2</td><td>2</td><td></td><td></td><td></td><td></td><td>TUBE ASS'Y</td><td>CRES 0.500 OD x 0.035 W</td><td>AISI 304</td></td<>	D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-103 T2003-103 12.38 12.00 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-105 T2003-105 10.75 10.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-107 T2003-107 12.75 12.25 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-111 T2003-111 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-120 T2003-120 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-205 T2003-205 9.75 9.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035	D2003-077	T2003-077	N/A	6.25									WW-T-700/6
D2003-105 T2003-105 10.75 10.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-107 T2003-107 12.75 12.25 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-111 T2003-111 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-120 T2003-120 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-14 T2003-16 4.0 HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLE D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-205 T2003-205 9.75 9.60 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700	D2003-101	T2003-101		13.13					2			6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107 T2003-107 12.75 12.25 2 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-600 D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-111 T2003-111 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-120 T2003-120 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-14 T2003-16 4.0 HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLE D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-205 T2003-205 9.75 9.60 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700	D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109 T2003-109 8.25 8.125 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-111 T2003-111 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-120 T2003-120 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-14 T2003-14 4.0 HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLE D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-205 T2003-205 9.75 9.60 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700	D2003-105	T2003-105	10.75	10.60					2	_ 2		6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-111 T2003-111 4.75 4.625 2 2 TUBE ASS'Y 6061-T6 0.500 OD x 0.035 W WW-T-600 D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLE D2003-120 T2003-120 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-14 T2003-14 4.0 HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLE D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-205 T2003-205 9.75 9.60 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700	D2003-107								2	2			WW-T-600/6
D2003-116 T2003-116 4.0 HEATSLEEVE M2650-20 CRINKLE-SOFT STRATOFLI D2003-120 T2003-120 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLI D2003-14 T2003-14 4.0 HEATSLEEVE M2650-14 CRINKLE-SOFT STRATOFLI D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLI D2003-205 T2003-205 9.75 9.60 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700													WW-T-600/6
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D2003-16 T2003-16 4.0 HEATSLEEVE M2650-16 CRINKLE-SOFT STRATOFLE D2003-205 T2003-205 9.75 9.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WWV-T-700													STRATOFLEX
D2003-205 T2003-205 9.75 9.60 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700													STRATOFLEX
													STRATOFLEX
D2003-207 T2003-207 3.75 3.75 2 2 TUBE ASS'Y 6061-T6 0.375 OD x 0.035 W WW-T-700						<u>. </u>							WW-T-700/6
	D2003-207	12003-207	3.75	3.75					2	2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APAROVED	DRAWING NO.	REV. B				
II.		D2003	SHEET 2 OF 2				
DATE		TITLE	SCALE				
99.06.08		206 CABIN HEATER TUBE	ASSEMBLIES NTS				



JNDER REVIEW

[06.08.21 (8)]

Some flot / 18.24

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

